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D2053

Job Sheet 181203



Part No: D2053

Job Qty: 6 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP D 02.03.18 Added Rev.B NG (Issue this IPP with part number D2052) IPP Rev:E now water jet 07-10-25 DD IPP Rev:F 08-05-14 chg to revC as per ECN1171 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Waterjet		SC 8/18/18
100	Waterjet	6 pcs	8/31/18	8/31/18	0.00	0.19	Waterjet1		SC 8/18/18
110	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Waterjet-1		SC 8/18/18
120	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC8-1		18-08-10
130	Brake NC	6 pcs	8/31/18	8/31/18	0.00	0.11	Brake NC 2		SR DAS
140	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC5		38
150	HandFinish	6 pcs	8/31/18	8/31/18	0.00	0.09	HandFinish1		DR 18/08/18
160	Powdercoat	6 pcs	8/31/18	8/31/18	0.00	0.07	Powdercoat4		DR 18-8-18
170	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC3		DR 18-8-18
180	Packaging	6 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-1		57001-06
190	QC21-SA	6 Ea	8/31/18	8/31/18	0.00	0.00	QC21		9-89

Part Op 100 - 1-Cut as per Dwg D2053 Dwg Rev: C Prog Rev: C ****grain direction along 1.987" **** 2-Deburr if

Descriptions: necessary

110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Form as per Dwg D2053 using CNC Brake

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - START TIME: 3.10 OVEN TEMPERATURE: 320° FINISH TIME: 3.40

170 - QC3- Inspect Part Finish

180 - Identify as per dwg & Stock Location:

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.090	5052-H32 .090 Sheet	.2400 sf (.04 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M5052H32S.090	0	49	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected U _____		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		Part: D2053 Job No: 181203 Serial No/Batch: S100795 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 09/09/18			
Description Work Order Deviation							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ BOIM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐					
OTHER : _____		Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					

Specifications could not be found.

Plex 7/24/18 9:15 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

